

Date: Monday, 3/5/2007 4:23:02 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: REDUCER TEE ASSY		
Job Number	: 31018					
Estimate Number	: 12762					
P.O. Number	: N/A		Part Number	: 41232 200 004 001		
This Issue	: 3/5/2007	S.O. No. : N/A	Drawing Number	: 41232-200-004 REV IR		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: IR		
Previous Run	: N/A		Material	: N/A		
Written By			Due Date	: 3/12/2007 Qty: . 12 Um: Each		
Checked & Approved By						
Comment	: Est Rev A New Issue 07-03-01 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	AN8154J	union	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) union Batch: M102929	E 07-03-19 (12)
2.0	AS1035J080812	TEE	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) TEE Batch: M103237	Jud 07-03-20 (12)
3.0	LATHE CONV.	CONVENTIONAL LATHE	
		Comment: CONVENTIONAL LATHE 1-Turn AN815-4J as per Dwg 41232-200-004 2-Deburr as Required.	E 07-03-19 (12)
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE 1-Drill as per Dwg 41232-200-004 2-Deburr	Jud 07-03-20 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

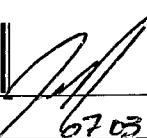
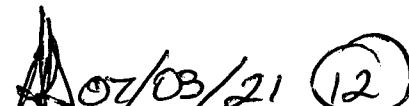
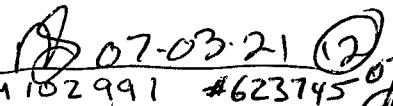
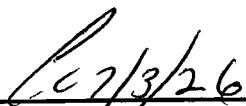
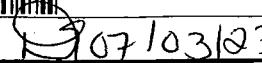
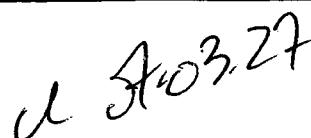
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/03/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/5/2007 4:23:03 PM  
User: Kim Johnston

## Process Sheet

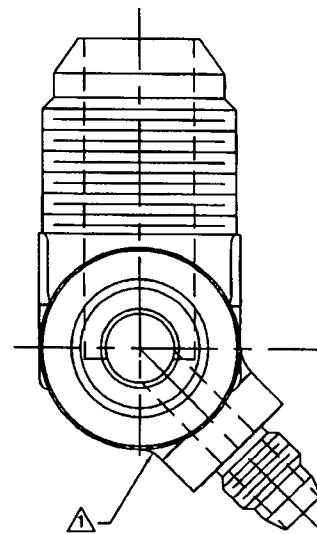
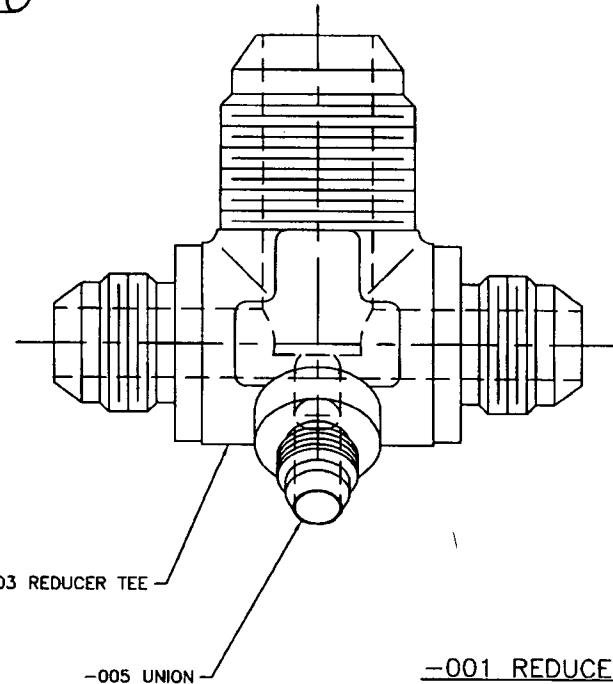
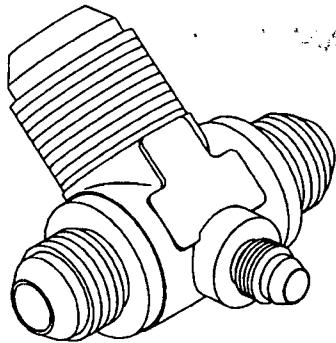
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: REDUCER TEE ASSY
Job Number: 31018		Part Number: 41232 200 004 001
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		 670320 (12)
6.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		 PC 07.03.20 (12)
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
1-Weld as per Dwg 41232-200-004 A/R SS Rod Batch: M102576		 A 07/03/21 (12)
8.0	QC5/9	WELD INSPECTION 
Comment: 1-WELD INSPECTION		PD 07.03.21 (12)
2-Pressure test as per Dwg 41232-200-004		 B 07-03-21 (12)
3-Passivate Finish. Pickling Solution Soudotec M102991 #623745 Passivating solution M102991 #624809		070323
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		 3/03/25 (12SD)
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 07/03/27 (12)
Job Completion		  d 3/03/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



-001 REDUCER TEE ASSY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31018

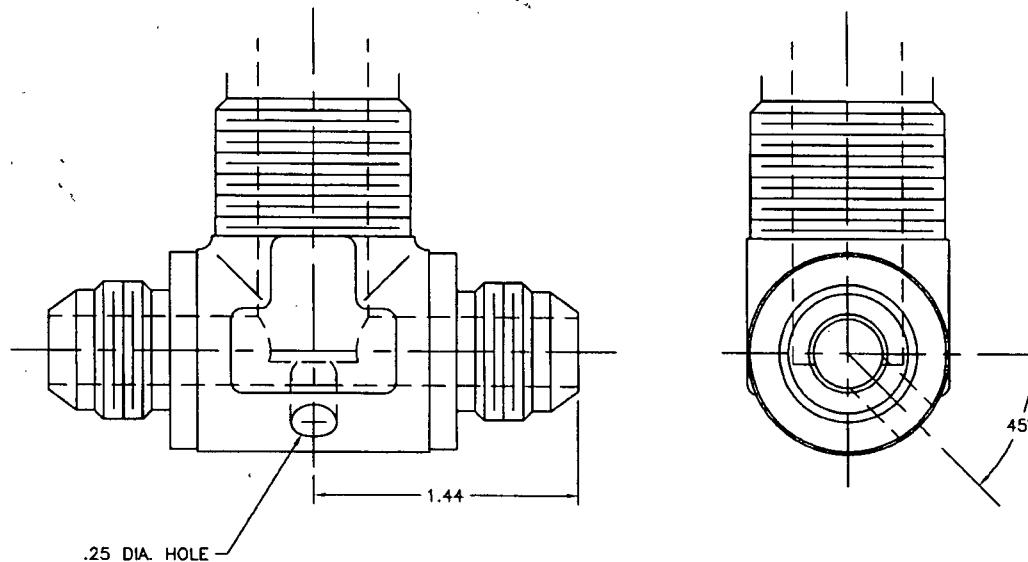
**(3) PRESSURE TEST TO 3,000 PSI.**

**△ QQ-P-35 PASSIVATE FINISH AFTER WELD.**

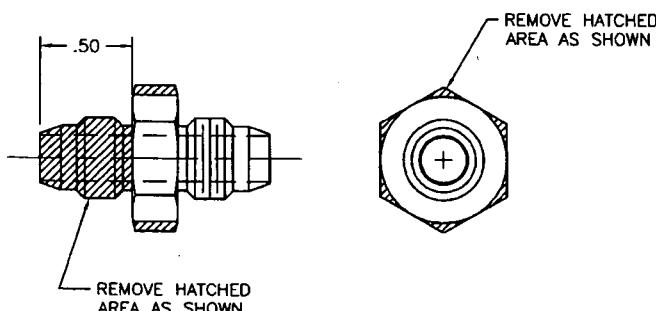
**▲ WELD IN ACCORDANCE WITH MIL-STD-2219 CLASS C**

**NOTES:**

			1	-005	UNION	MAKE FROM AN815-4J UNION		
			1	-003	REDUCER TEE	MAKE FROM BELL P/N AS1035J080812 or 110-080-12C		
				-001	REDUCER TEE ASSY			
			-001	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC
NO. REQ'D PER ASSY		LIST OF MATERIAL						
PROPRIETARY RIGHTS NOTICE					DRAFTSMN D. NELSON	5/24/02	TITLE	
THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC. DISCLOSURE, COPIES, REDUCTION, OR USE OF THESE DATA FOR ANY PURPOSE OTHER THAN MANUFACTURE OF THE ITEM FOR WHICH THEY WERE PROVIDED IS NOT WITHOUT WRITTEN AUTHORIZATION FROM ERA AVIATION, INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.					CHECK D. MURPHY	5/24/02		REDUCER TEE ASSY
					STRESS			
					PROJ. ENGR.		DRWG. SIZE C	SCALE 2:1
					ANGLES $\pm 1/2^{\circ}$			
					HEAT TREAT			
					FINISH	▲	Era Aviation, Inc.	DRWG. NO. 41232-200-004 REV. IR
			-001	2	41232-000-001			SHT 1 OF 2
			REQ'D PER ASSY		NEXT ASSEMBLY	REV.		
					REV.			



-003 REDUCER TEE



-005 FITTING

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WORK ORDER  
NO. 31018

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Era Aviation, Inc.	
TITLE REDUCER TEE ASSY	REVISION NO. C SHT 2 OF 2

REV.  
IR

DART AEROSPACE LTD	Work Order:	
Description: Ice Plug.	Part Number:	41K32-200-030
Inspection Dwg:	Rev: IR	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## First Article Prototype

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	
Date:	07.03.20	Date:	07.03.20	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/RF	